

Work Order ID 81995 -1

March 21, 2012 3:05:29 PM

81995

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Item ID: D2807-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Door prop

Start Date: 3/21/12

Start Qty: 40.00

40

Cust Item ID:

Required Date: 3/26/12

Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan: *CL*

Date: *12/03/12* Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D2807

Rev E

0.00

100

100

Purchasing

PURCHASING

Memo

0.00

Purchasing

Issue P/O: *16521* Order as per Dwg D2807 Possible
supplier: Lift Support Technologies, Saskatoon, Canada P/N 6/15-164/50-115N

Material release note is required

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

120

QC- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

15 12/04/04

SPC

Work Order ID 81995

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March 21, 2012 3:05:29 PM

Item ID: D2807-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Door prop

Start Date: 3/21/12 Start Qty: 40.00

40

Cust Item ID:

Required Date: 3/26/12 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/4/15 *[Signature]*
mf
12-04-04

Picklist Print

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Page 1

Work Order ID: 81995
Parent Item: D2807-041
Parent Item Name: Door prop

Start Date: 3/21/12

Required Date: 3/26/12

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: D 07.11.12 een1019, replaces D2807 ECverified by DD
IPP Rev:E 08-02-12 ECN 1111 DD verified by: ee

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
6/15-164/50-115N Gas Spring		Purchased	No			130	Each	0.0000	1	40			
D3671-1 Placard		Manufactured	No			110	Each	12.0000	1	40			

Location

Loc Qty

Loc Code

GA

12

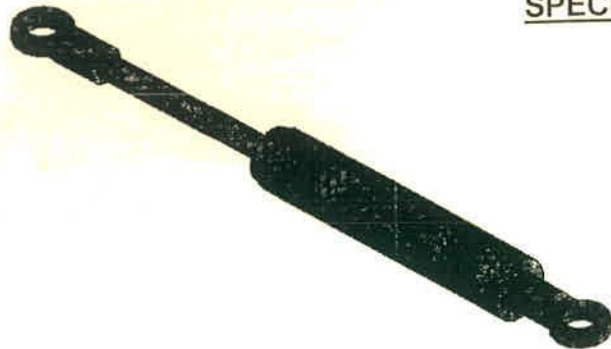
80368

12

B

12/13/12 3/13
12/04/04
B81996
20

SPECIFICATION CONTROL DRAWING



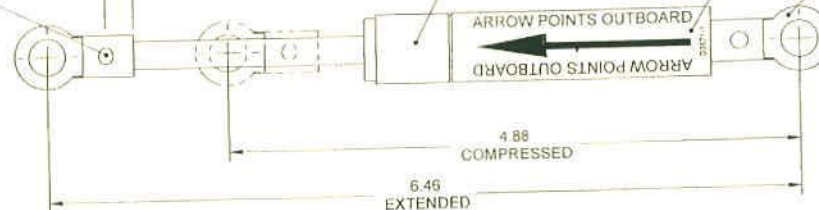
(ALTERNATE ONLY)
[8] CRIMP 0.015-0.025 DEEP
WITH $\phi 0.375$ TOOL AT
2000psi (REF) TYP TWO
SIDES PER LUG

[8] 0.24 TO CRIMP
(TYP)

D2807-5
OR
(ALTERNATE ONLY) D2807-1

AFFIX D3671-1 PLACARD
ENSURE PLACARD DOES NOT
CONCEAL ANY TEXT OR MARKINGS
ON THE GAS SPRING.

[8] (ALTERNATE ONLY) D2807-3
BOTH ENDS



D2807-041 GAS SPRING

D2807-041 GAS SPRING ASSEMBLY PARTS LIST

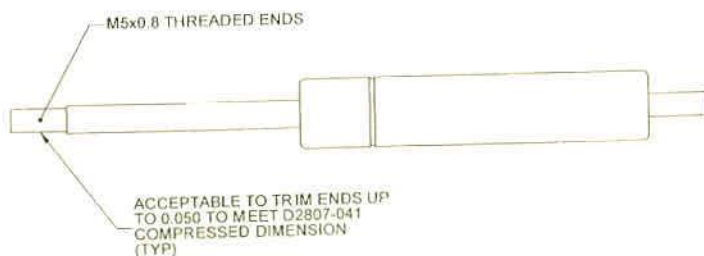
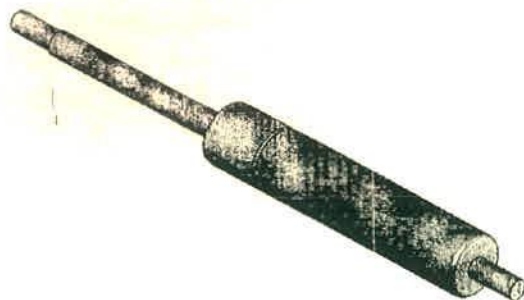
QTY -041	PART NUMBER	DESCRIPTION
X	D2807-041	GAS SPRING ASSEMBLY
1	D2807-5	GAS SPRING
1	D3671-1	PLACARD

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) ALTERNATE PART: D2807-5 CAN BE MADE FROM ASSEMBLING D2807-1 (1) AND D2807-3 (2)
(WEIGHT: 0.176 LBS)

CL 1210721
Q101 81495

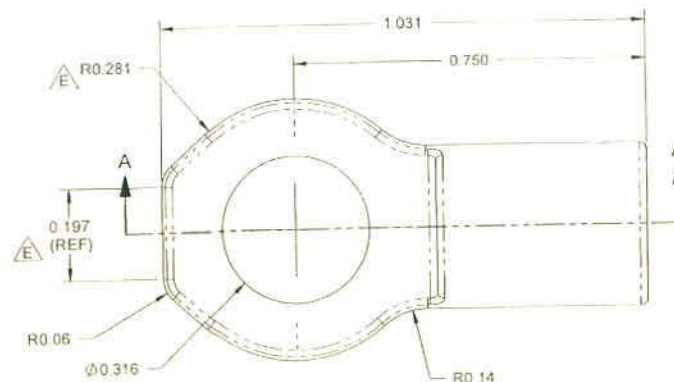
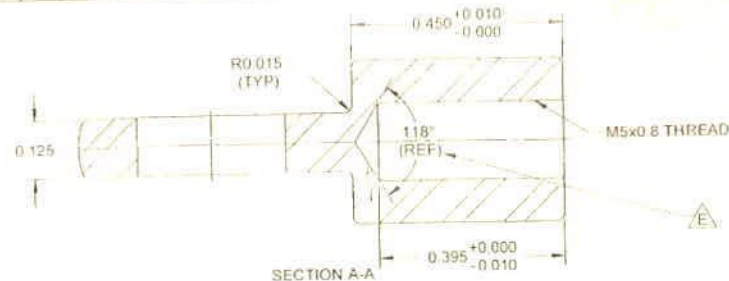
E	ADD D2807-5 GAS SPRING. D2807-1/-3 ASSEMBLY IS AN ALTERNATE TO D2807-5 GAS SPRING, UPDATE DIMENSIONS ON D2807-3	PH	07.12.28
D	ADDED D3671-1 PLACARD ADDED -041 ASSEMBLY UPDATED DWG	DC	07.09.27
C	CHANGE SPRING TO SS, ADD -3 LUG	CP	05.05.25
B	ADD FINISH	CP	05.03.16
A	NEW ISSUE	DS	00.11.03
REV	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>PH</i>		
CHECKED	<i>JE</i>	DRAWING NO.	REV E
MFG APPR	<i>JE</i>	D2807	SHEET 1 OF 3
APPROVED	<i>JE</i>	TITLE	SCALE
DE APPR	<i>JE</i>	GAS SPRING	NTS
DATE	07.12.28	<small> COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DRAWING IS THE PROPERTY OF DART AEROSPACE LTD AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD. </small>	



D2807-1 GAS SPRING
SCALE 1:1

D2807-1 GAS SPRING NOTES:

- 1) POSSIBLE SUPPLIER: ARVINMERITOR MOTION CONTROL SYSTEMS, LEICESTER, UK
(P/N SXF6S6050080S6L-115N)
(REF: 80MM LONG CYLINDER, 50MM STROKE, 115N LOAD)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.144 LBS
- 8) SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 LB (115 N) MIN TO 45 LB (200 N) MAX
M5x0.8 THREADS



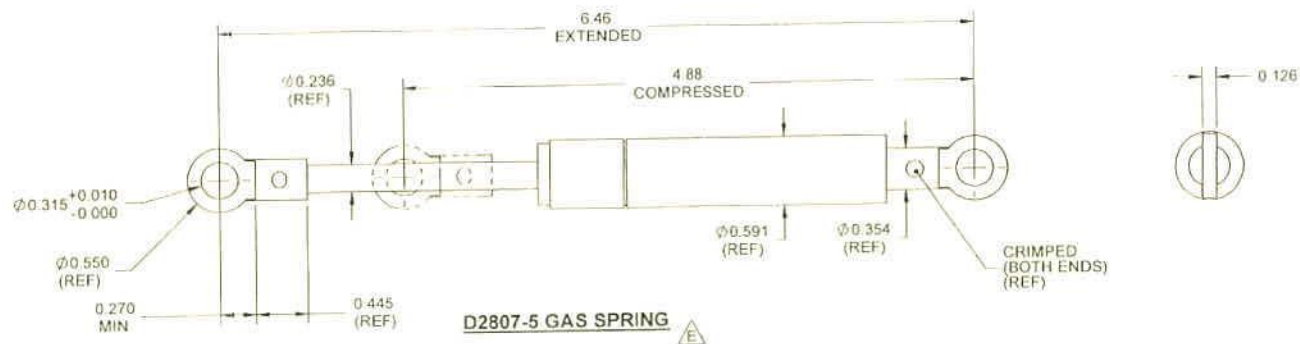
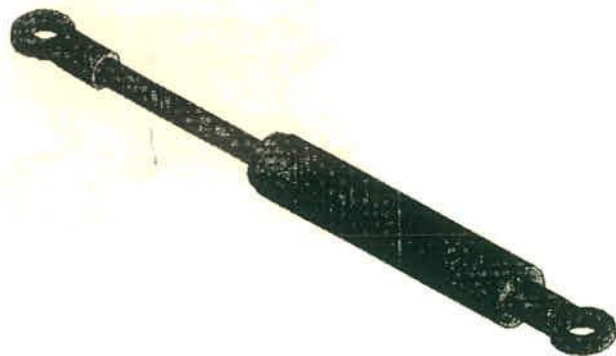
D2807-3 LUG

D2807-3 LUG NOTES:

- 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.016 LBS

DESIGN	HT
DRAWN	HT
CHECKED	LE
MFG. APPR	HT
APPROVED	HT
DE APPR	HT
DATE	07.12.28

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO D2807	REV. E SHEET 2 OF 3
TITLE GAS SPRING	SCALE 4:1
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D2807-5 GAS SPRING

D2807-5 GAS SPRING NOTES:

1) POSSIBLE SUPPLIER: LIFT SUPPORT TECHNOLOGIES, SASKATOON, CANADA
(P/N 6/15-164/50-115N)

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: N/A

6) IDENTIFICATION: N/A

7) WEIGHT: 0.169 LBS

8) SPECIFICATION: SS GAS SPRING WITH END FITTINGS.

ACCEPTABLE LOAD RANGE 25 LB (115 N) MIN TO 45 LB (200 N) MAX

DESIGN	#4	DART AEROSPACE LTD	
DRAWN	#4	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KE	DRAWING NO.	REV. E
MFG. APPR.	KE	D2807	SHEET 3 OF 3
APPROVED	KE	TITLE	SCALE
DE APPR.	KE	GAS SPRING	4:1
DATE	07.12.28	COPYRIGHT © 2000 BY DART AEROSPACE LTD	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO16521

Purchase Order Date 3/21/2012

PO Print Date 3/21/2012

Page Number 1 of 1

Order From :

VC-LST0001

LS TECHNOLOGIES INC.
314 JESSOP AVE
SASKATOON, SK S7N 1Y6
CA

Contact Name		Buyer	Brigitte Golden
Vendor Phone	306 683 5000	Requisition Nbr	
Vendor Fax	306 683 6403	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	615-164/50-115N	Gas Spring	3/23/2012 Yes	40.00 Each	FedEx Overnigh	\$63.9000	\$2,556.00

Special Inst: AS PER DWG: D2807 REV:E
B81995

PO Total: \$2,556.00

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 3/21/2012

LS TECHNOLOGIES INC

314 Jessop Ave
Saskatoon, SK S7N 1Y6

Ph # (306) 683-5000

Packing Slip

P.O. No.	Date	Invoice #
16521	22/03/2012	8409

Name / Address
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship To
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship	Via	FOB
22/03/2012		

Qty	Description
15	D2807 Stainless Gas Spring (6/15-164/50-115N) Shipping Via FED EX Tracking # 793369171183



LS Technologies Inc
314 Jessop Ave
Saskatoon, SK, S7N 1Y6
Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Compliance

This is to certify that the parts listed below meets specifications as required by your order.

20 Units: D2807 Stainless Gas Spring (6/15-164/50-115N)


Country of Manufacture: Canada
Date of Manufacture : MARCH 2012
This product is ROHS compliant.

We certify no mercury was used in the manufacture of this order.

Purchase Order # PO16521
Invoice # 8409

March 22, 2012

L S Technologies Inc Canada



Nolan Felm
Manager